

Work Order ID: 67250

Monday, March 14, 2011 10:43:28 AM

BLUE



Page 1

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 11/03/14 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441

CHG002

N/A

**Work Order ID 67250**

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Reference:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R ☐ Aluminum Rod

4-Grind weld flush to cap on top surface only.

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 &amp; DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

&gt; DP

11-3-16

M111385/M116577

BE 11-03-23

BE 11-03-23

BE 11/03/23

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

116

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

S u/09/25

S u/09/25

(X1)

BB 11/03/28

**Work Order ID 67250**

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Stop



Item Name: Replacement Skidtube

Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 861/03/29

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Stop



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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail  
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.  
cure time before cutting□  
Start Date: 11/03/31 □

Time: □ 11:00

□  
Finish Date: 11/03/31 □

Time: □ 11:30

A/R □ Sikaflex-291 □ 116040 □ □

Sikaflex expiry date: □ 11/07/30

3 BE 11/03/29

BB 11/03/31

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

8/14/11



QC

Memo

0.00

Quality Control



160

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.  
A/R Aluminum Rod ☐ M11385 BE 1/6 4/10

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Deburr

&gt; DP 11-4-7

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  Skidtubes Skidtubes	HandFinishing  Memo Install D2680-041 Nut Plate as per Dwg D2650	0.00  0.00							
180  QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00							
190  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							

DP 11-4-7

Sublog

Sublog

④

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Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Pressure Wash per QSI005 4.3	0.00							
	HandFinish	0.00							
Hand Finishing	<div>Memo Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.</div>								
205	Spray Painting per QSI005 4.2	0.00							
	SprayPaint	0.00							
Spray Painting	<div>Memo Spray Painting: prime grey B: 117319 spray paint delfleet blue B: 115985 clear delfleet B: 117113</div>								
220	<div>QC14 QC3- Inspect Part Finish</div>	0.00							
	QC	0.00							
Quality Control	<div>Memo</div>								

225

QC14

Inspect Paint

Permanent Change B

B

11 24

27-1



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Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

230

0.00



HandFinishing

HandFinish

**Memo**

0.00

Hand Finishing

1-Install inserts &amp; wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

✓ A/R ☐ Sikaflex-291 ☐ M116040Sikaflex expiry date: ☐ 11/08

✓ 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

✓ 3-Install MS27039-4-06 Screw as per DEO 9153

✓ 4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

✓ A/R ☐ Sikaflex-291 ☐ M116040Sikaflex expiry date: ☐ 11/08✓ 6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4 ☐Batch: M1173151 0 all 11/04/25

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Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
250	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-441								
	Location: _____								
	PPP Rev: <u>PPP</u> <u>67250</u>								
260	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11 04 28 ①

2/16/13

11/5/14

ME  
11-05-06

# Picklist Print

Monday, March 14, 2011 10:43:24 AM

Page 1

Work Order ID: 67250

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube



Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM  
 IPP Rev:I 08-05-01 add QC3 DD verified by:EC  
 IPP Rev:J 08-09-29 revF as per dwg DD verified by: EC IPP rev K  
 10.09.27 SS washers for wearplates EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620  
  
 Skidtube, 206 Skidtube

Manufactured No

110

Each

15.0000

1

1

Location

Loc Qty

Loc Code

LG

15

62684  
 64784

6  
 9

D2646  
  
 Aft Cap

Manufactured No

110

Each

71.0000

1

1

Location

Loc Qty

Loc Code

FP-4

1

57332

1

FP6

16

52663

3

62678

12

63633

1

Return 2010

54

62678

54

D2647  
  
 Cap

Manufactured No

140

Each

51.0000

1

1

Location

Loc Qty

Loc Code

LG002

51

55352

51

① 11-3-16  
 11/04/25

BC 9013

AL

BE 11/03/23

11/03/23

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Work Order ID: 67250



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

D2654-7 Manufactured No

160 Each

4.0000

1

1



Web

67001



1

11/03/31

Location

Loc Qty

Loc Code

LG

4

67016

4

CCR264SS3-3

Purchased No

170 Each

332.0000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

332

112314

4

113539

44

113973

88

117086

196

D2649

Manufactured No

170 Each

120.0000

23

23



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG001

120

58545

2

60652

4

61496

2

62889

11

63359

3

65317

98

D2680-041

Manufactured No

170 Each

14.0000

1

1



Nut Plate

Location

Loc Qty

Loc Code

ST020

14

55366

14

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Shop Packet Print

# Picklist Print

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Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130 Purchased

No

230

Each

626.0000

60

60



Handwritten: 11/04/27

Insert

Location

Loc Qty

Loc Code

PKG11

491

1117331

Handwritten: X60

114723

42

116864

449

ST281

135

110511

10

114654

39

115911

86

AN960JD10L NAS1149D0332J Purchased

No

230

Each

4.0000

2

2



Handwritten: (x2): 11/04/27

Washer

Location

Loc Qty

Loc Code

ST335

4

11912

4

AN960JD416 NAS1149D0463J Purchased

No

230

Each

30.0000

1

1



Handwritten: 11/04/27

Washer

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

1116805

Handwritten: x1

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Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

230

Each

1,837.000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

MEZZ

1837

110139

2

110153

35

111359

5

112314

2

114436

448

114450

31

114859

1314

D2651-1

Manufactured

No

230

Each

571.0000

22

22



Plug

Location

Loc Qty

Loc Code

FP

189

51530

152

62638

37

fpa

382

53349

205

57869

117

66445

60

D2651-3

Manufactured

No

230

Each

404.0000

22

22



O-Ring

Location

Loc Qty

Loc Code

FP

404

46114

12

61962

392

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Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011



Required Date: 3/25/2011

Start Qty: 1.00



Required Qty: 1.00

D3535-15      Manufactured      No      230      Each      22.0000      1      1  
            11/04/22  
Wearshoe

Location	Loc Qty	Loc Code
FP18	22	
63569	3	
<u>66238</u>	6	
66558	13	

D3535-23      Manufactured      No      230      Each      18.0000      1      1  
            11/04/22  
Wearshoe

Location	Loc Qty	Loc Code
FP021	18	
63571	4	
<u>66236</u>	13	

D3535-37      Manufactured      No      230      Each      7.0000      1      1  
            11/04/22  
Wearshoe

Location	Loc Qty	Loc Code
FP	7	1367612
56101	1	
62716	6	

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Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-15

Manufactured No

230 Each

36.0000

1

1



xl 11/04/27

Gasket

Location	Loc Qty	Loc Code
FP	1	
56055	1	
FP011	34	
63568	8	
66559	26	xl
FP11	1	
59238	1	

D3536-23

Manufactured No

230 Each

36.0000

1

1



xl 11/04/27

Gasket

Location	Loc Qty	Loc Code
FP	10	
66240	10	xl
FP011	26	
63570	1	
66560	25	

D3536-37

Manufactured No

230 Each

24.0000

1

1



xl 11/04/27

Gasket

Location	Loc Qty	Loc Code
FP	24	
63237	12	xl
66823	12	



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Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-1  
  
 Manufactured No  
 Wearpad

230 Each 28.0000 6 6



32 11/04/27

Location

Loc Qty

Loc Code

FP017

28

366935

x6

37749

5

65057

23

D3537-3  
  
 Manufactured No  
 Wearpad

230 Each 20.0000 1 1



32 11/04/27

Location

Loc Qty

Loc Code

FP17

20

65929

20

x1

MS27039-1-08  
  
 Purchased No  
 Screw

230 Each 1,059.000 2 2



32 11/04/27

Location

Loc Qty

Loc Code

ST291

1059

110835

319

115108

740

x2

MS27039-4-06  
  
 Purchased No  
 Screw

230 Each 91.0000 1 1



32 11/04/27

Location

Loc Qty

Loc Code

ST292

91

109061

4

115460

87

x1

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Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039C1-08

Purchased

No

230

Each

959.0000

60

60



Handwritten: 11/04/27

SCREW

Location

Loc Qty

Loc Code

FP

63

115336

63

ST293

896

115589

347

116022

148

116373

400

19185

1

Handwritten: x60

NAS1149C0332R

Purchased

No

230

Each

1,958.000

60

60



Handwritten: 11/04/27

Washer

Location

Loc Qty

Loc Code

ST297

1958

115000

125

115698

35

116025

28

116304

1770

Handwritten: 1117291

Handwritten: x60

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

SHOP COPY  
RETURN TO  
ENGINEERING  
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NO. 67250

*02/10/03/14*

RELEASED  
*03-23-14*

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP, DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 1 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206/407 SKIDTUBE ASSEMBLIES	NTS
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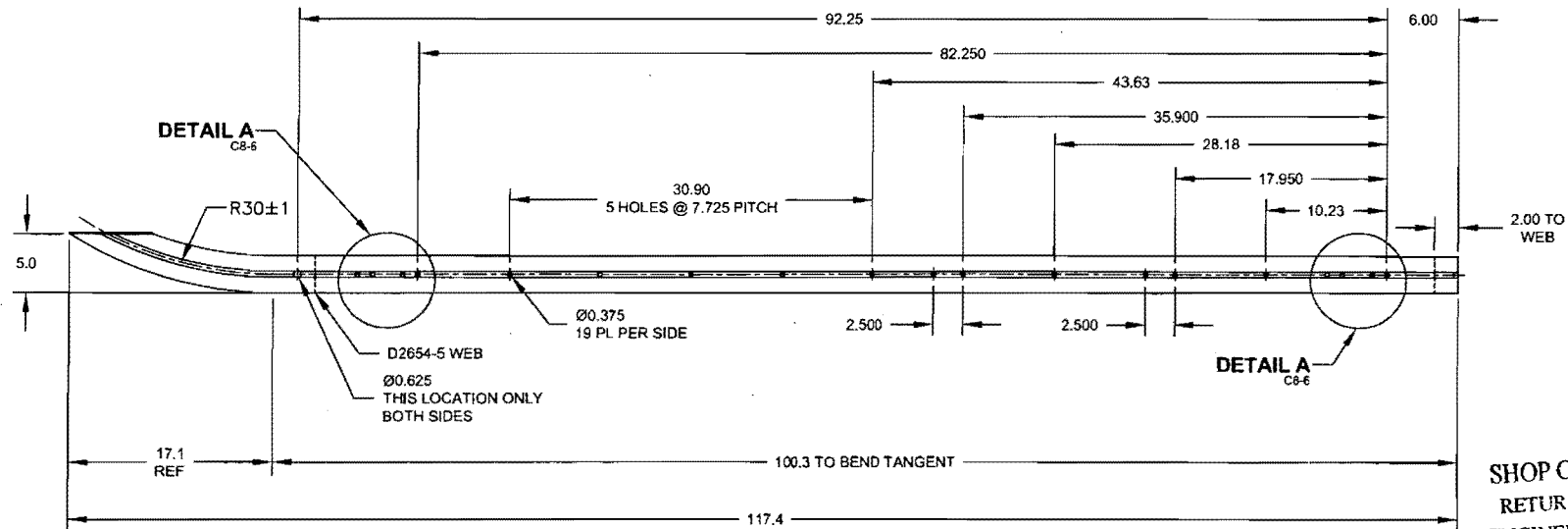




### D2650-3 ASSEMBLY/FINISHING DETAIL

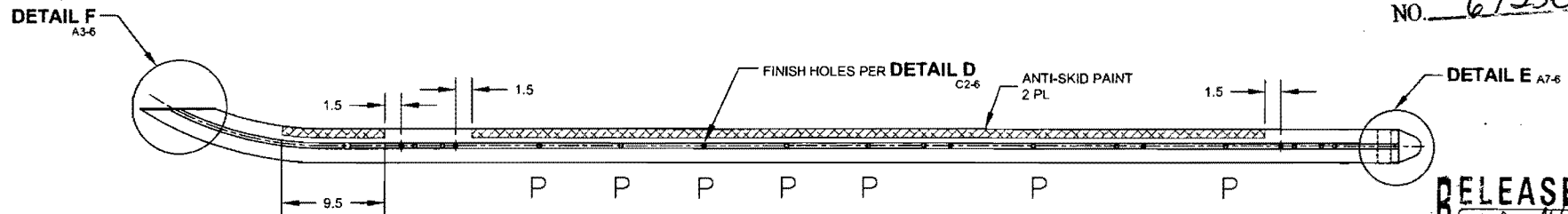
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05-07-22 114

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



**D2650-5 BENDING/DRILLING DETAIL**

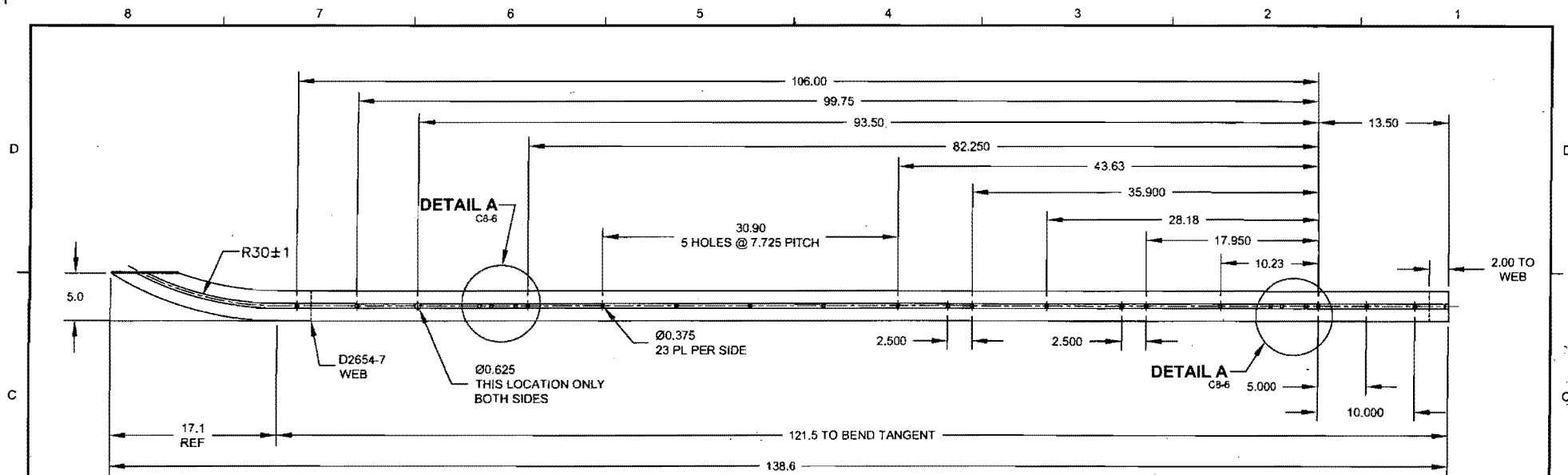
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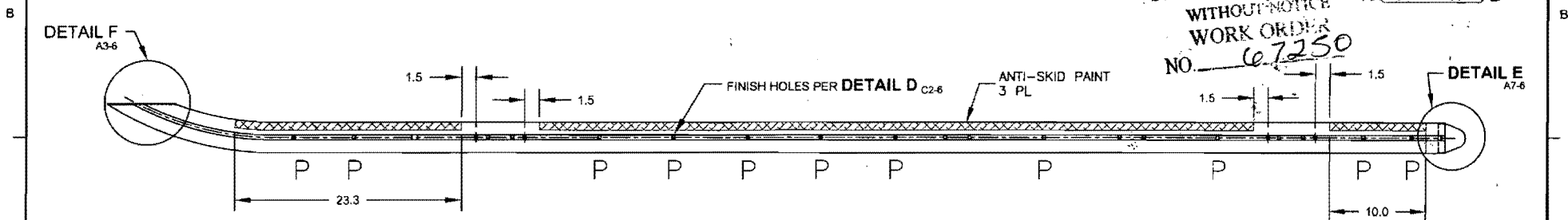
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**D2650-7 BENDING/DRILL DETAIL**

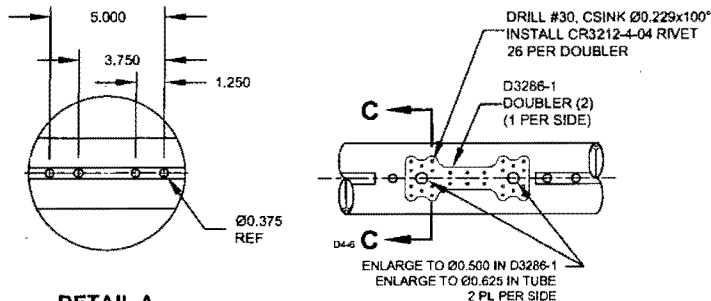


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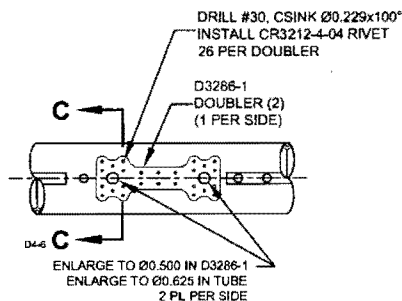
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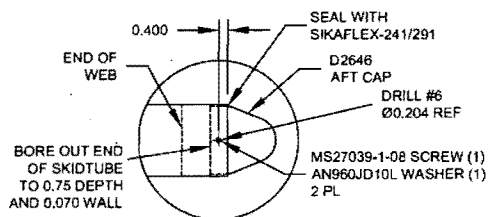
**DETAIL A**  
SCALE 2X

C2-2  
D7-2  
C2-3  
D7-3  
C2-4  
D7-4  
C2-5  
D6-5



**DETAIL B**  
SCALE 2X

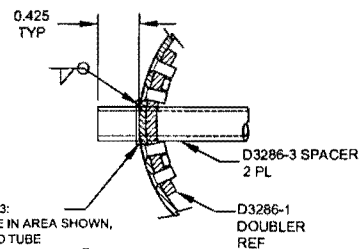
C3-2  
C3-3



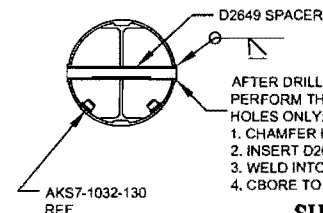
**DETAIL E**  
SCALE 2X

B2-2  
B2-3  
B1-4  
B1-5

**SECTION C-C** C7-6  
SCALE NONE



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
  2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  3. ENLARGE HOLES IN D3286-1 TO Ø0.500
  4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
  5. RIVET D3286-1 TO TUBE
  6. INSERT D3286-3 SPACER
  7. WELD IN PLACE.



**DETAIL D**  
FOR Ø0.375 HOLES ONLY  
SCALE 3X

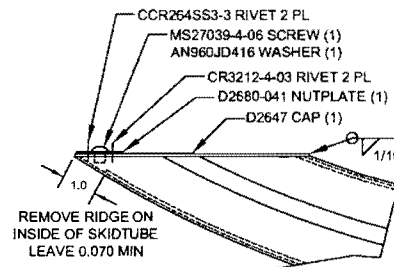
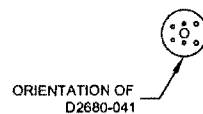
B4-2  
B4-3

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**DETAIL F NOTES:**

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE





NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



**DETAIL F**  
SCALE NONE

B8-2  
B8-3  
B8-4  
B8-5

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NO. 246

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barkley Elliott  
Job number: 66462  
Part number: D206-642-441  
Description: 206 skirt tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat Gunn Date of Test Coupon 11-03-09

Welder Barkley Elliott Date of Test Coupon 11-03-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld